

## **AMENDMENTS TO THE SPECIFICATION**

**Please amend the paragraph beginning on page 2, line 1 as follows:**

However, if the die cushion capacity is increased and the production rate further rises, an excessively large peak pressurizing force is generated at the instant of time the upper mold and lower mold are brought into contact. This peak pressurizing force is called a surge pressure, and a peak value increases in the air with a large compressibility. A variety of problems such as vibrations, noise, cracking of press frame, equipment failure, and low-quality processing of works were associated with such surge pressure. Accordingly, a technology has recently been used by which the die cushion pad was caused to move down immediately prior to the contact of the upper mold and lower mold in order to reduce the surge pressure. Such an operation control of the die cushion pad is called pre-acceleration. ~~An NC (Numerical Control)~~A Numerical Control (NC) die cushion shown, for example, in Japanese Examined Utility Model Application No. 7-47195 (column 4, lines 40-48, FIG. 1) is known as an example of the pre-acceleration.

**Please amend the paragraph beginning on page 9, line 1 as follows:**

~~FIG. 1 shows a hydraulic circuit of the die cushion apparatus in accordance with an embodiment of the present invention. FIG. 2 is a partial cross-sectional view of a hydraulic cylinder unit. FIG. 3 is a partial cross-sectional view of a booster cylinder.~~

**Please amend the paragraph beginning on page 9, line 4 as follows:**

A die cushion pad 2 is supported on the lower surface side thereof ~~with~~by a hydraulic cylinder unit 5 together with a pneumatic cylinder unit 80. Because the pneumatic cylinder unit 80 is identical to that used in the conventional die cushion, the explanation thereof is herein omitted. A first rod 21 is connected to the lower surface of the die cushion pad 2, and the pressurizing force acting when the die cushion pad 2 is lowered is applied to a hydraulic cylinder unit 5 via the first rod 21.

**Please amend the paragraph beginning on page 9, line 4 as follows:**

If locking of the locking member 81 is released, the die cushion pad 2 rises under the effect of the restoration force of the air pressure of the pneumatic cylinder unit 80. On the other hand, the pressure oil from the hydraulic pump 3 and accumulator 4 is supplied to the first hydraulic chamber 53 of the hydraulic control unit 5, and the pressure of the pressure oil inside the first hydraulic chamber 53 gradually rises. However, the actuation speed of the hydraulic control unit 5 is lower than that of the pneumatic control unit 80. In other words, the lift speed of the second rod 54 is less than the lift speed of the first rod 21. As a result, the first rod 21 and second rod 54 are separated, and after the die cushion pad 2 reaches the upper dead center, the first rod 21 and second rod 25 are brought into contact again. Because the first rod 21 and second rod 54 are thus separated, when the die cushion pad 2 ~~reached~~reaches the upper dead center, the pressure of the hydraulic control unit 5 does not act upon the die cushion pad 2. A damper member 82 using the working oil is provided in the pneumatic control unit 80 to moderate the impact occurring when the die cushion pad 2 reaches the upper dead center, but a load applied to the damper member 82 is not increased due to the extension of the second rod 54.